

Date: Wednesday, 10/10/2007 11:03:42 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT		
Job Number	: 35081B					
Estimate Number	: 10462					
P.O. Number	: N/A		Part Number	: D32782		
This Issue	: 10/10/2007 S.O. No. : N/A		Drawing Number	: D3278 REV. C		
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: C		
Previous Run	: 34951B		Material	: N/A		
Written By			Due Date	: 10/31/2007 Qty: 20 Um: Each		
Checked & Approved By						
Comment	: Est:A 04.04.19 New issue KJ/JLM Est B 07.09.06 Rev C dwg EC Verified by: JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"		
		Comment: Qty.: 0.2454 f(s)/Unit Total : 4.9077 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000)	Batch: M105817	<i>DKL 07/11/06</i>
2.0	SHEAR	SHEAR		
		Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long		<i>DKL 07/11/06</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-2		<i>DKL 07/11/06</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<i>DKL 07/11/06</i>
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK		<i>DKL 07/11/06</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/11/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/10/2007 11:03:42 AM
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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HD

07-11-07

X20

7.0 POWDER COATING

POWDER COATING



M105194

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

HD

07-11-07

X20

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M. K

07/11/07

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 80

7/11/07 SO

(20X)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/11/08

Job Completion



U 8/11/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35081B
Description: Support	Part Number:	D3278-2
Inspection Dwg: D3278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø0.099	—			
0.359	+/-0.005	0.360	—			
0.609	+/-0.010	0.613	—			
0.250	+/-0.010	0.250	—			
1.480	+/-0.005	1.480	—			
R0.125	+/-0.010	R0.125	—			
0.119	+0.005/-0.004	0.115	—			
2.439	+/-0.010	2.440	—			
1.980	+/-0.010	1.980	—			
R0.13	+/-0.030	R0.130	—			
Ø0.257	+0.005/-0.000	Ø0.260	—			
R0.375	+/-0.010	R0.376	—			
0.875	+/-0.010	0.875	—			
0.500	+/-0.010	0.500	—			
R0.400	+/-0.010	R0.400	—			
R1.00	+/-0.030	R1.00	—			
1.720	+/-0.010	1.723	—			
R0.125	+/-0.010	R0.125	—			
0.125	+/-0.010	0.127	—			

Measured by:	<i>JNL</i>	Audited by:	<i>BG</i>	Prototype Approval:	N/A
Date:	07/11/06	Date:	07.11.06	Date:	N/A

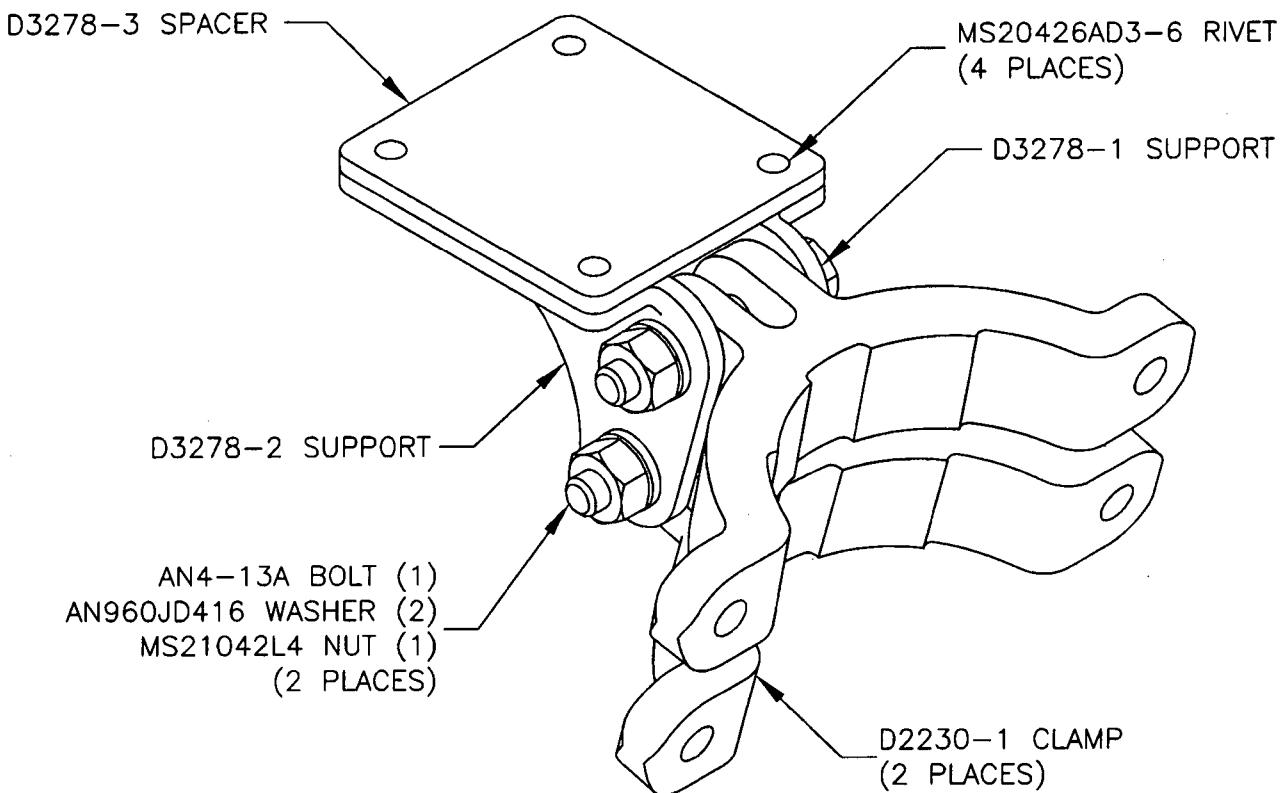
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC <i>KJ</i>	<i>EZ</i>

DART

DESIGN <i>91</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>JH</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07.08.06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description	
X	D3278-041	SUPPORT ASSEMBLY	
2	D2230-1	CLAMP	
1	D3278-1	SUPPORT	
1	D3278-2	SUPPORT	
1	D3278-3	SPACER	
2	AN4-13A	BOLT	SHOP COPY
4	AN960JD416	WASHER	RETURN TO ENGINEERING
4	MS20426AD3-6	RIVET	CONTROLLED COPY
2	MS21042L4	NUT	SUBJECT TO AMENDMENT

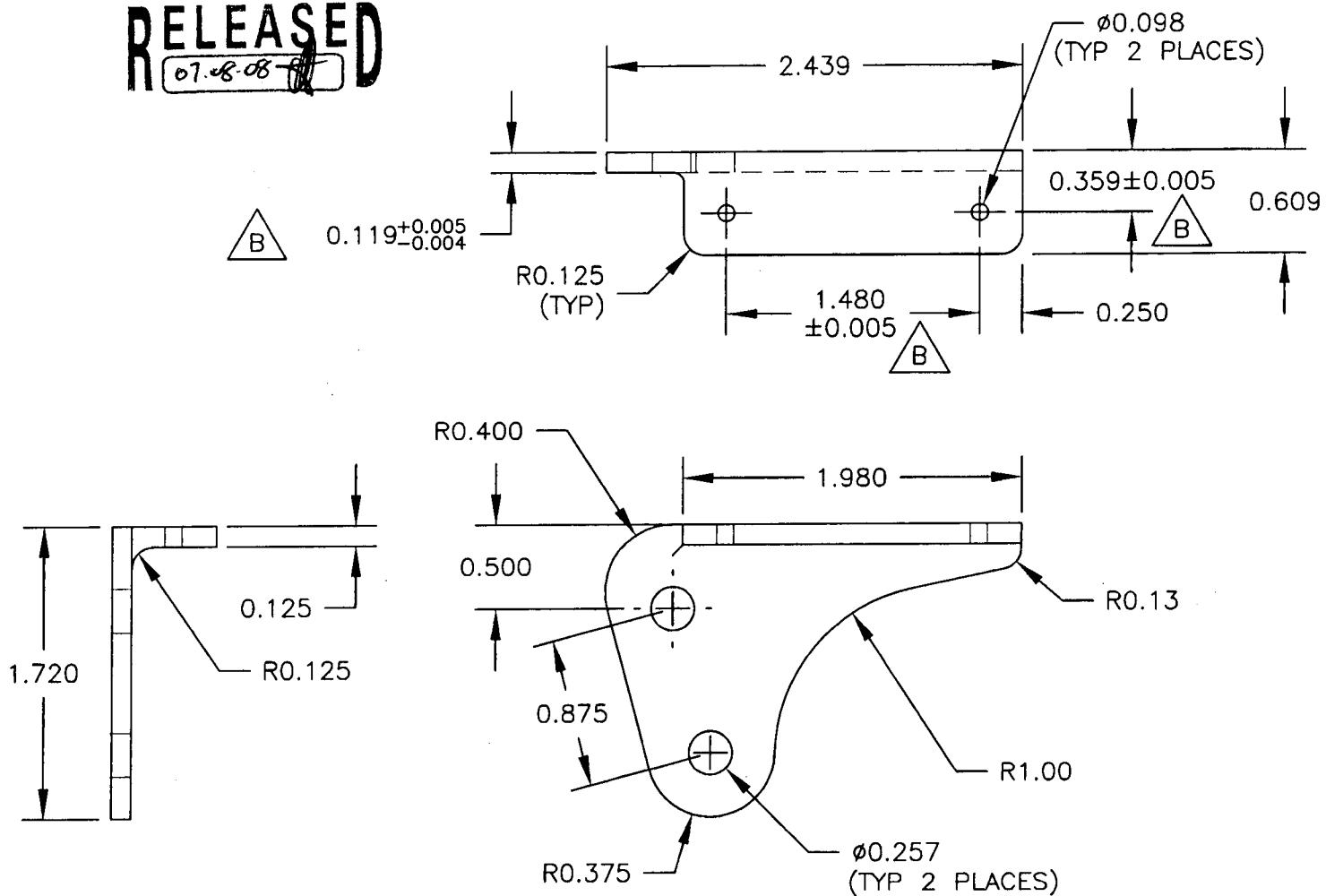
UN
WITHOUT NOTICE
WORK ORDER
NO. *35081B*

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DART

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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C	SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1	

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRPT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

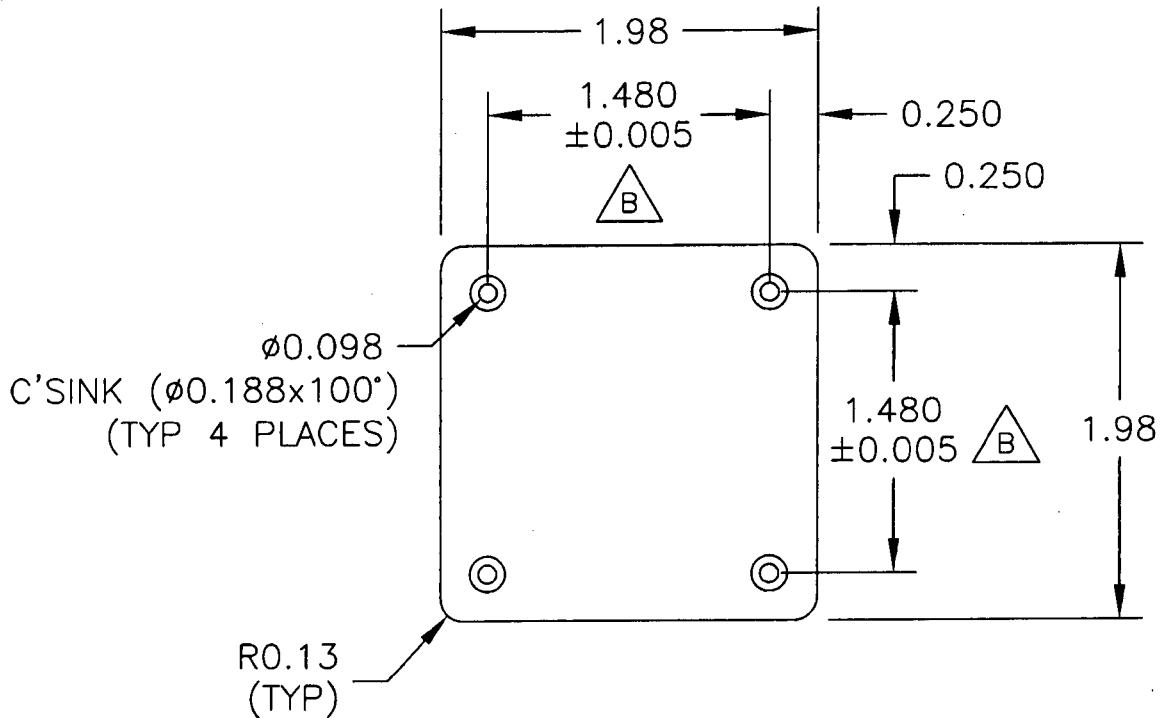
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DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY	SCALE 1:1	

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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